

Date: Friday, 5/25/2007 8:16:31 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 32579
 Estimate Number : 10613
 P.O. Number : *N/A*
 This Issue : 5/25/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : PURCHASED PARTS
 Previous Run : 31113
 Part Number : D265615
 Drawing Number : D2656 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : *N/A*
 Due Date : 6/10/2007 Qty: *26* Um: Each
 Written By :
 Checked & Approved By : *07.05.28*
 Comment : Est: D 02.10.25 Re-format KJ
 Est Rev:E Now on Waterjet 06-09-25 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.6431 sf(s)/Unit Total : 16.0781 sf(s)

1010/1025/A21/6aA SHEET (.040")

(M1010S20GA)

Batch: *M/04 752*

SAD

07/06/19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: *8*

Prog Rev: *0*

2-Deburr if necessary

SAD 07/07/04 (26)

SAD 07/06/19

(26)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/19

(26)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

So 07/06/07

Counter

(26)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158

3-Identify as D2656-15

SAD 07/07/16

(26)

SAD 07/07/18

(26)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:16:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32579

Part Number: D265615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counted
End of 7/18 *(26)*

7.0

POWDER COATING

POWDER COATING



M104846



(26X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/07/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-L 07/07/21



(26)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(26X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-14

M-L 07/07/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/23

Job Completion



U 07/07/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

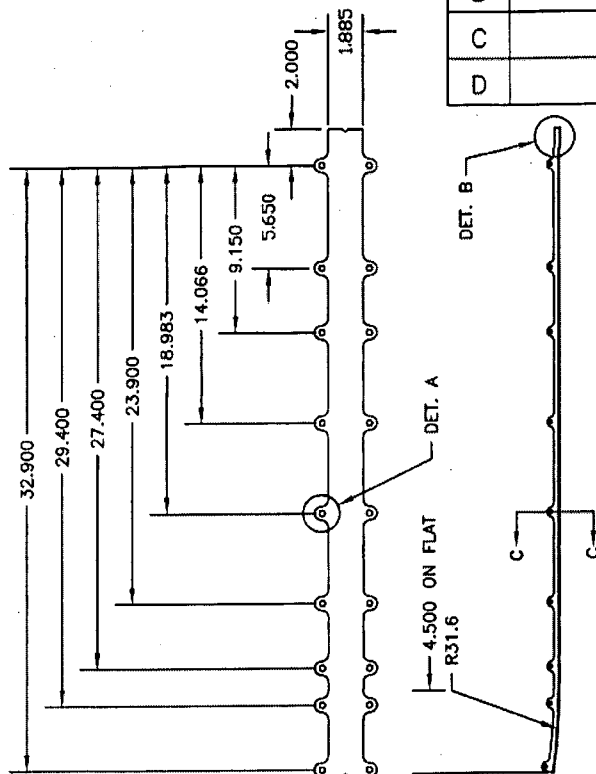
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

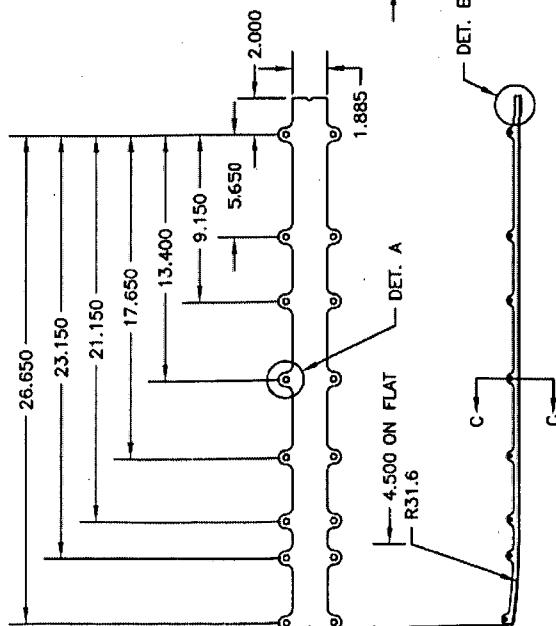


DESIGN DS		DRAWN BY CP		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17		TITLE WEARSHOE		SCALE 1:10	
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT.		

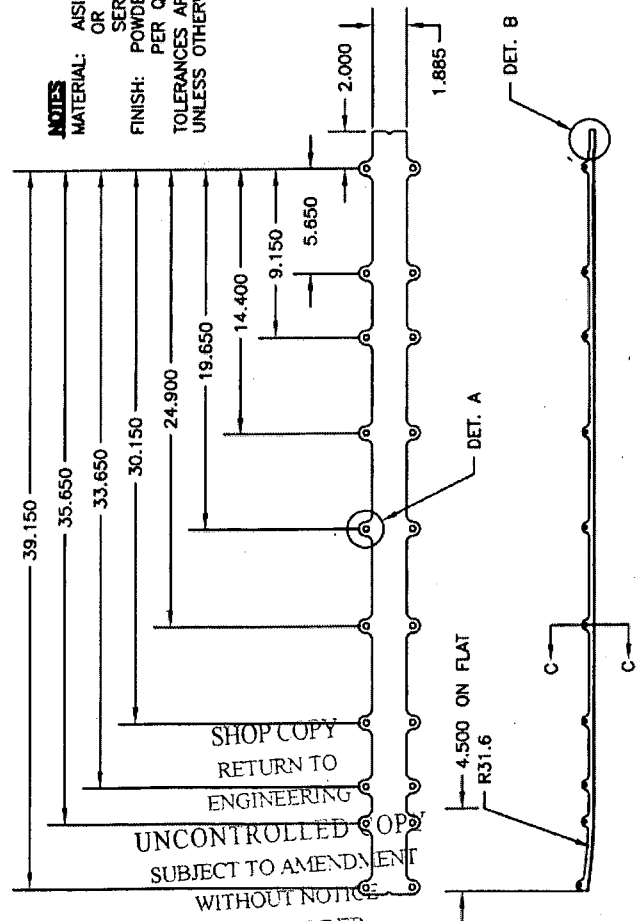
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.02

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WORK ORDER
NO. 32579

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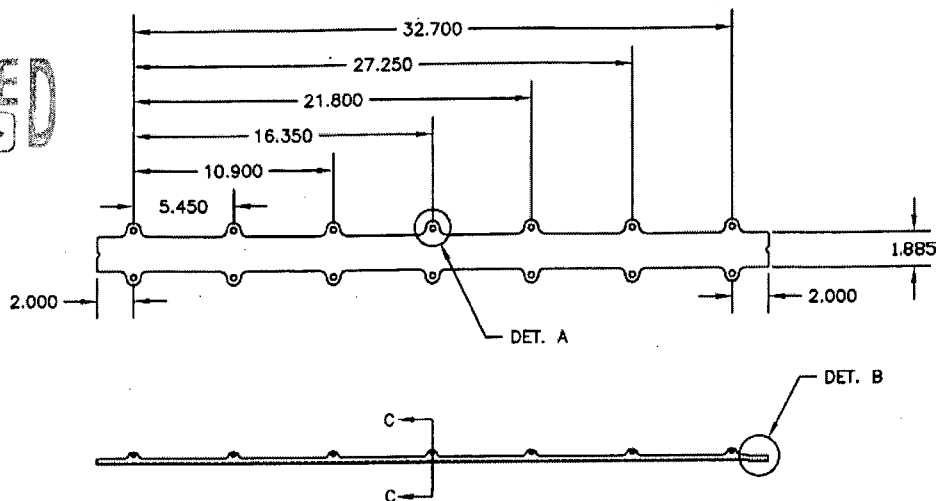
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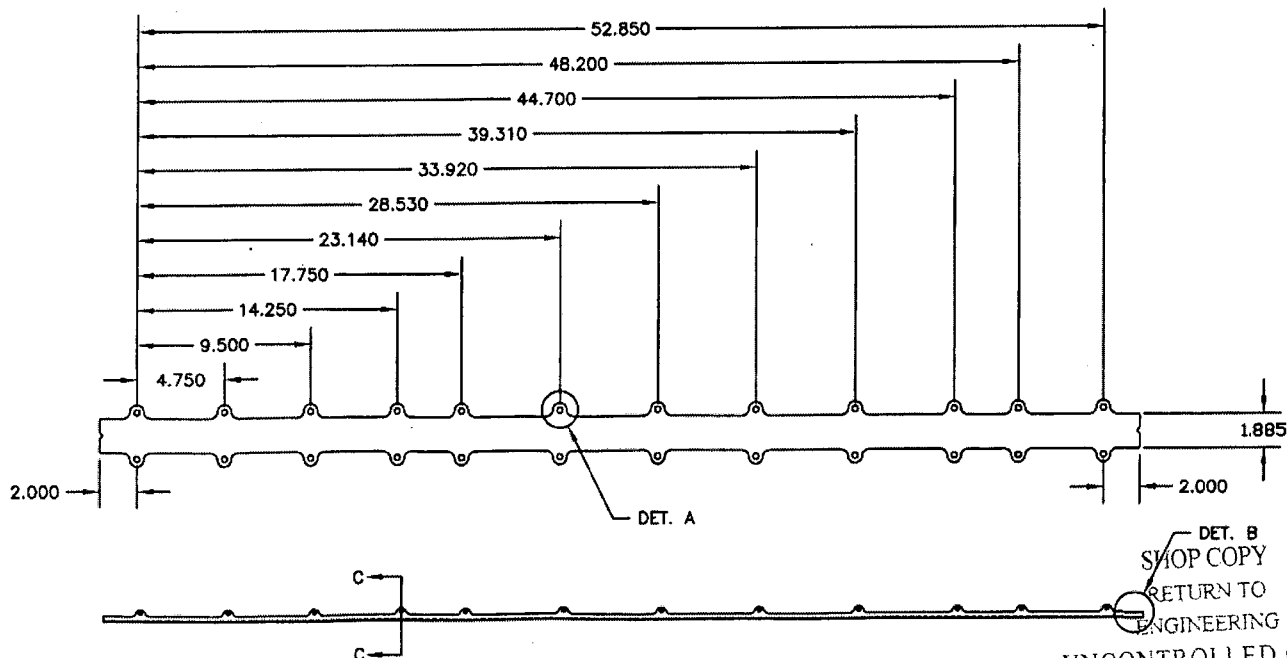
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DATE 05.08.17		TITLE WEARSHOE SCALE 1:10	

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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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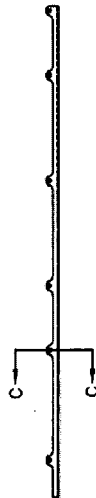
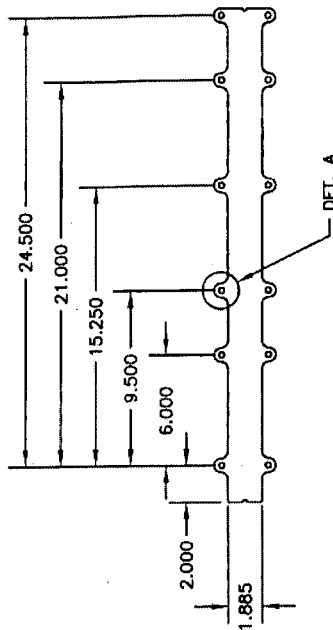
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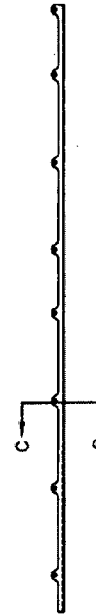
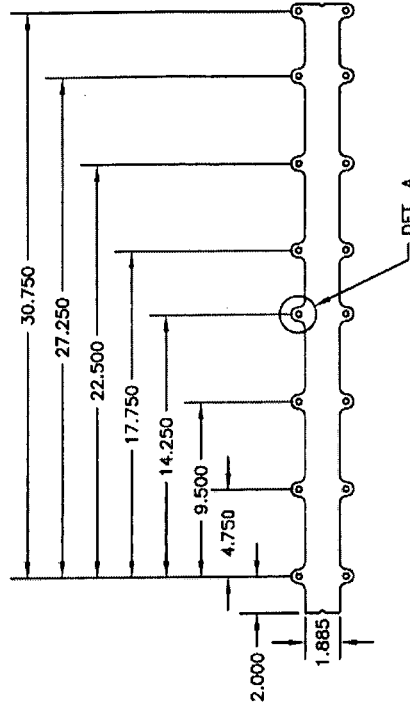


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DATE 05.08.17		TITLE WEARSHOE SCALE 1:10	

D2656-33

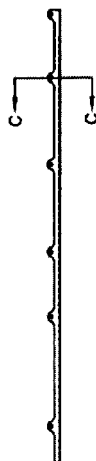
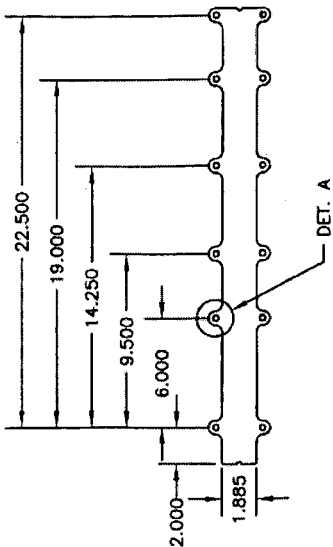


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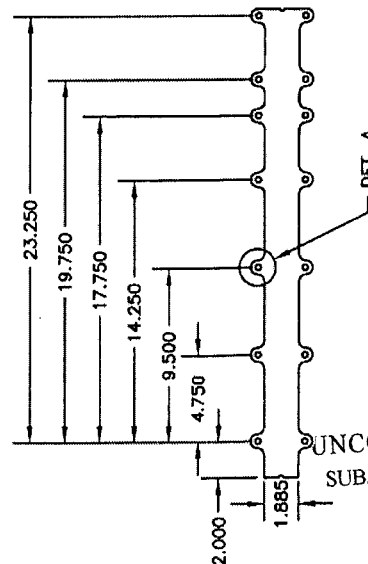


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SERIES STEEL, 20 GAUGE (0.040 THICK)
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TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

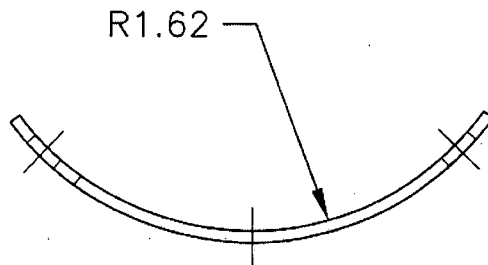
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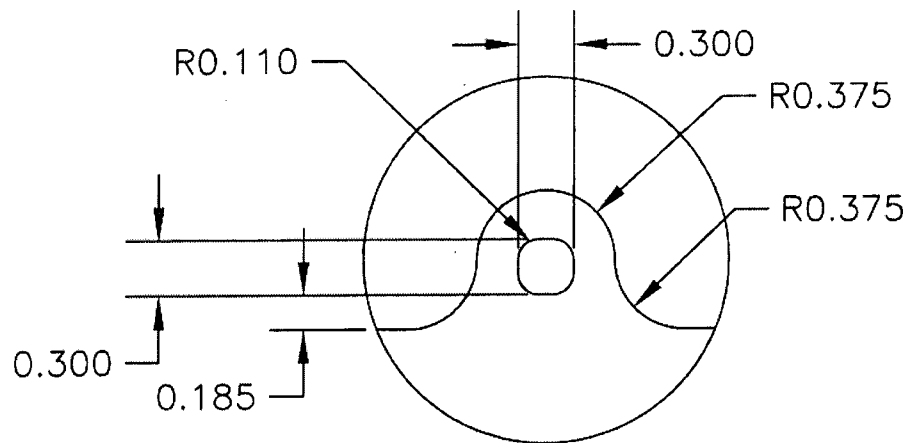
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

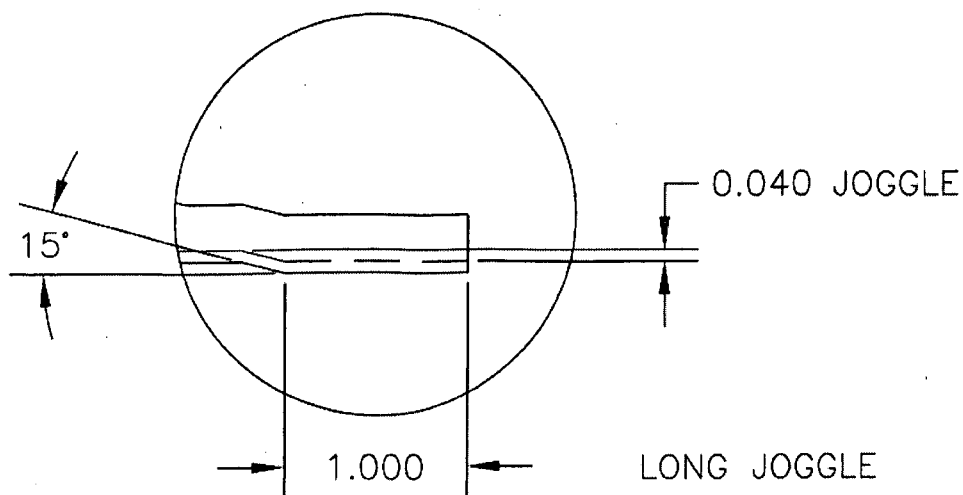


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DETAIL A



DETAIL B



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DART AEROSPACE LTD		Work Order: 32 579
Description: WEARSHOE		Part Number: D265615
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 39.150	+/-0.010	39.150	✓		M-T	
B 35.650	+/-0.010	35.650	✓		M-T	
C 33.650	+/-0.010	33.650	✓		M-T	
D 30.150	+/-0.010	30.150	✓		M-T	
E 24.900	+/-0.010	24.900	✓		M-T	
F 19.650	+/-0.010	19.650	✓		M-T	
G 14.400	+/-0.010	14.400	✓		M-T	
H 9.150	+/-0.010	9.150	✓		Vern	
I 5.650	+/-0.010	5.653	✓		Vern	
J 2.000	+/-0.010	2.000	✓		Vern	
K 1.885	+/-0.010	1.892	✓		Vern	
L 0.040	+/-0.010	0.036	✓		Vern	mpt. Thickness
M 0.300	+/-0.010	0.298	✓		Vern	
N 0.300	+/-0.010	0.299	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: S.A.D.	Audited by: S.D.	Prototype Approval:	N/A
Date: 07/06/19	Date: 07/06/19	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

